

Work Order ID 75195

October-18-11 3:28:00 PM

75195

Page 1

Item ID: D3684-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: MOUNT ASSEMBLY
 Start Date: 18/10/2011 Start Qty: ~~4.00~~ ***4*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/18 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3684	Rev D

100 Pick Kit 0.00
100
 Packaging Memo 0.00
 Packaging

110 Small Fab 0.00
110
 Small Fab Memo 0.00
 Small Fab
 1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 2-Assemble D3684-049 & D3687-1
 Using Sikaflex -241/-291 between mating surfaces as per Dwg
 D3684***Ensure holes for AN3C Bolts are free o

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00
 Quality Control

4 FF 12-04-09
M111791
M119508
Schuler
SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75195

Page 2

N900040100

Setup Start *NS1*

Stop ***NS2***

4

4

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

0.00

4x

SP

12-04-10

0.00

0.00

Quality Control

12/4/10 Jf

010-0110

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Picklist Print

October-18-11 3:28:04 PM

Page 1

Work Order ID: 75195

75195

Parent Item: D3684-043

D3684-043

Parent Item Name: MOUNT ASSEMBLY

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A		Purchased	No			110	Each	70.0000	4	16			

AN3C12A

Bolts

** (4) FF 12-04-09

Location	Loc Qty	Loc Code
ST351 121259	70	→ 16
117514	4	
118112	5	
118422	17	
118451	22	
118838	22	

D3684-047

Manufactured No

110

Each

0.0000

1

4

D3684-047

FWD LEG ASS'Y

B 79051

**

4 (4) FF 12-04-09

D3684-049

Manufactured No

110

Each

0.0000

1

4

D3684-049

AFT LEG ASS'Y

B 79045

**

4 (4) FF 12-04-09

D3687-1

Manufactured No

110

Each

0.0000

1

4

D3687-1

MOUNT

B 77271

**

4 (4) FF 12-04-09

D3692-1

Manufactured No

110

Each

141.0000

8

32

D3692-1

SPACER

**

(4) FF 12-04-09

Location	Loc Qty	Loc Code
ST075	141	
51467	41	
73232	100	
78607		
		315

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Work Order ID: 75195

Parent Item: D3684-043

Parent Item Name: MOUNT ASSEMBLY

75195

D3684-043

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

921.0000

4

16

MS21043-3

Nut

**

(4) #12-04-09

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

849

118077

1

118614

492

118686

356

16

W/O:		WORK ORDER CHANGES					
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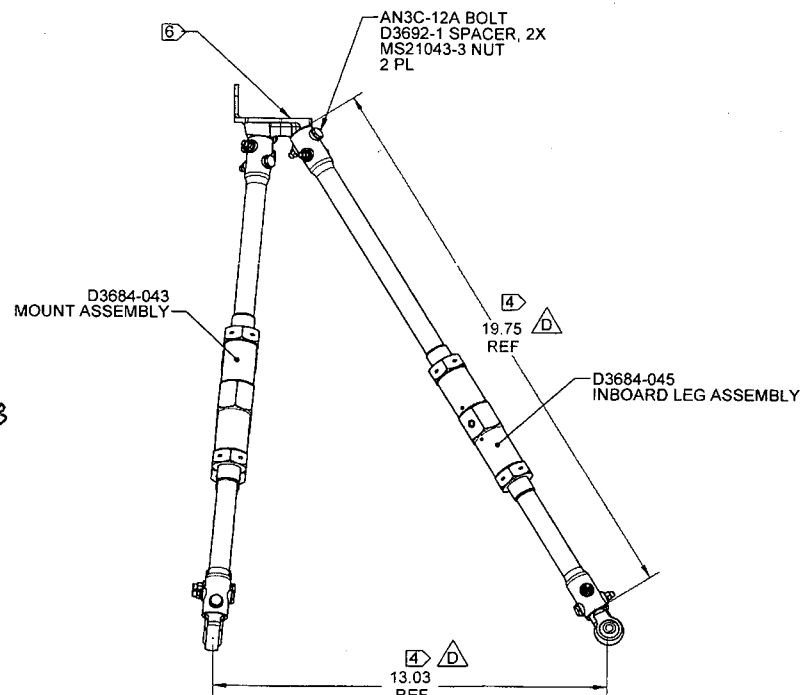
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ITEM	QTY .041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
4	4	D3692-1	SPACER
5	2	AN3C-12A	BOLT
6	2	MS21043-3	NUT

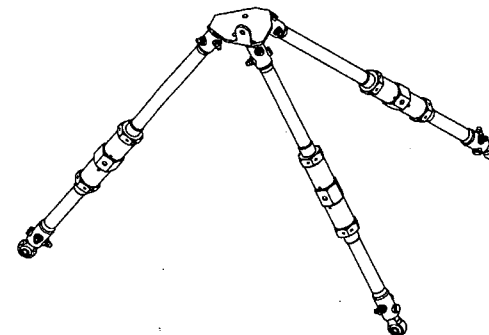
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75195-M.C.J
11110/18



D3684-041 TRIPOD MOUNT ASSY 7

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3/-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 9.9 lbs
- 6) ASSEMBLE D3684-045 WITH D3684-043 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT
- 7) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED



RELEASED
2010-03-15
mf

D	13.03 WAS 13.10 (ZN B5-1); 19.75 WAS 19.87 (ZN C4-1); 19.40 WAS 19.52 (ZN C6-2); 17.15 WAS 17.27 (ZN C4-2); 19.85 WAS 20.24 (ZN B5-2); 20.98 WAS 21.09 (ZN C5-3); 20.62 WAS 20.74 (ZN C5-4); 18.37 WAS 18.49 (ZN C6-5)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D6-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C6-2); 20.74 WAS 21.24 (ZN C5-4); 6.95 WAS 6.88 (ZND5-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	#		
MFG. APPR.	#		
APPROVED	#		
DE APPR.	#		
DATE	10.03.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D SHEET 1 OF 5
DRAWING NO. D3684	SCALE NTS
TITLE TRIPOD MOUNT ASSY	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

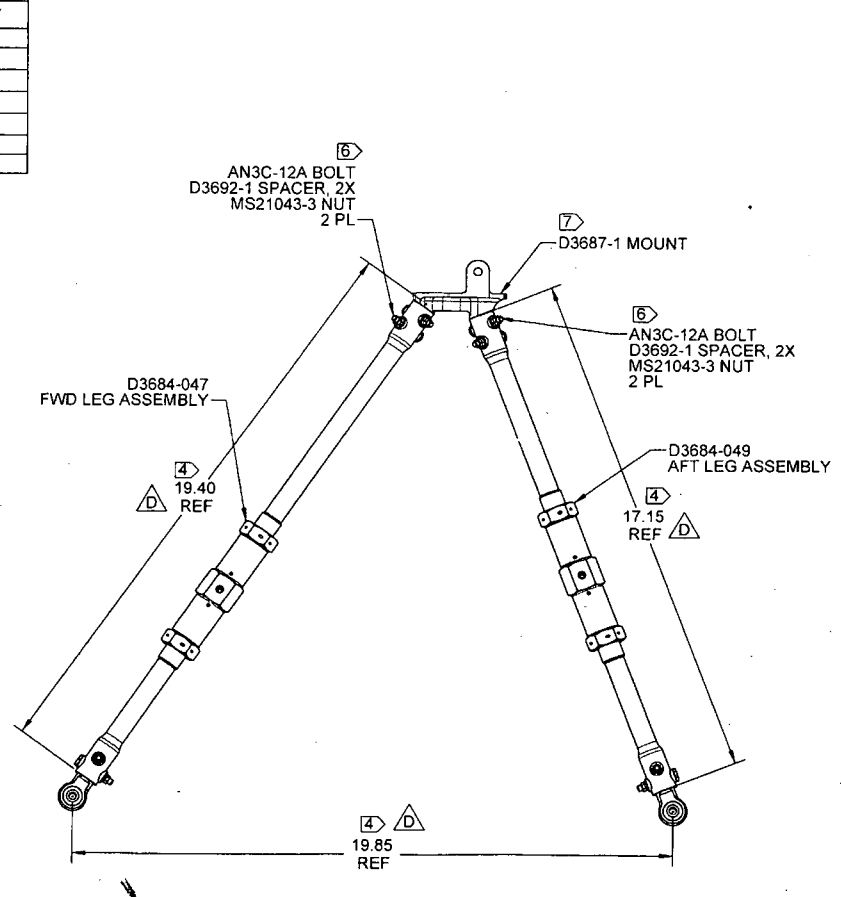
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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75195

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

- NOTES:
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 2) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
 - 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
 - 5) WEIGHT: 6.6 lbs
 - 6) TORQUE FASTENERS TO 20-25 in-lbs
 - 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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2010-03-15

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MFG. APPR.		D3684	SHEET 2 OF 5
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DE APPR.		TRIPOD MOUNT ASSY	NTS
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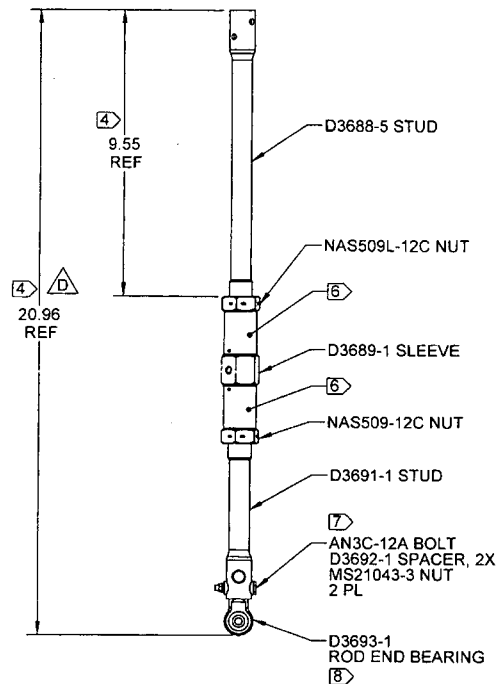
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-045 INBOARD LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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MFG. APPR.		D3684	SHEET 3 OF 5
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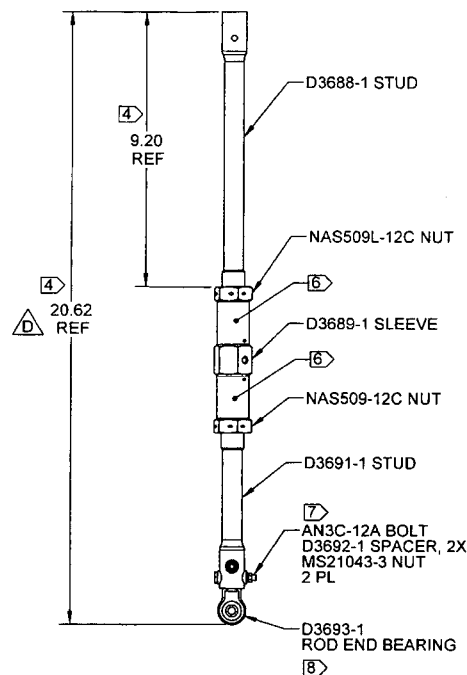
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT

**D3684-047 FWD LEG ASSEMBLY**

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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MFG. APPR.	<i>[Signature]</i>	D3684	SHEET 4 OF 5
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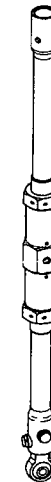
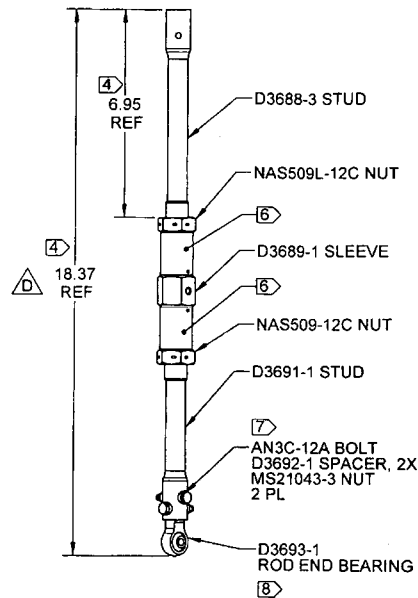
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT







D3684-049 AFT LEG ASSEMBLY

RELEASED
2010-03-15

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- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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